

# Work Order ID 75321

October-20-11 2:54:52 PM

**\*75321\***

Page 1

Item ID: D206-559-023

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 20/10/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/10/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN-D206-559	rev L								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-559-023 CHG007								
160	Pick Kit	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

W 11 11 01 (2)  
for MLJ 11-10-31 (2)

SP 11-11-1

W 11 11 01 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75321

**\*75321\***

Page 2

October-20-11 2:54:52 PM

Item ID: D206-559-023

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 20/10/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-023 Location: _____								
	<i>Mr B</i>								
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

*P44/10/12*

*11/11/02*

*mf 11-11-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-20-11 2:54:56 PM

Page 1

Work Order ID: 75321

**\*75321\***

Parent Item: D206-559-023

**\*D206-559-023\***

Parent Item Name: Bearpaw

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

## Comments:

IPP Rev: E04.02.17 Tolerance added to Step 3KJ/JLM  
 IPP Rev: F 07-01-02 Was K10006 JLM  
 IPP Rev: G 08-09-19 Added step 2 JLM Verified By: EC  
 IPP Rev: H New Manufacturing Method 08-10-29 JLM Verified By: EC  
 IPP Rev: J 10.10.04 per DSI9527 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>*AN4-17A*</b> x2 Bolt		Purchased	No			160	Each	736.0000	12	24			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST358		136							
				116419		0							
				116704		0							
				117514		36							
				<u>117619</u>		100			24x				
				ST359		600							
				118628		300							
				118983		300							
<b>*AN4-20A*</b> x2 Bolt		Purchased	No			160	Each	730.0000	12	24			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		730							
				116419		130			8x				
				<u>117514</u>		200			4x / 6x				
				118983		100							
				119127		200							
<b>*AN960.ID416*</b> x2 Washer	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	48			
**													

m 119042 SP 11-11-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-20-11 2:54:56 PM

Page 2

Work Order ID: 75321

**\*75321\***

Parent Item: D206-559-023

**\*D206-559-023\***

Parent Item Name: Bearpaw

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2182B

Manufactured No

160

f

43.7582

2.5

5

**\*D2182B\***

Rubber Cushion

\*\*

**B73932. Sp.**

Location

Loc Qty

Loc Code

ST410

43.75817

66063

43.75817

(D2182B050) cut qty (6) at 5.00" as per dwg \*\*\*per kit\*\*\*

D2274

Manufactured No

160

Each

640.0000

12

24

**\*D2274\***

Radius Block

\*\*

**Sp.**

Location

Loc Qty

Loc Code

ST010

640

69736

5

72121

401

73389

234

**24x**

D2438

Manufactured No

160

Each

302.0000

6

12

**\*D2438\***

Clamp

\*\*

**Sp.**

Location

Loc Qty

Loc Code

ST456

302

69737

108

73400

194

**12x**

D2529

Manufactured No

160

Each

635.0000

12

24

**\*D2529\***

Washer

\*\*

**Sp 11-11-1**

Location

Loc Qty

Loc Code

ST016

635

71161

250

73486

385

**24x**

October-20-11 2:54:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October-20-11 2:54:57 PM

Page 3

Work Order ID: 75321

**\*75321\***

Parent Item: D206-559-023

**\*D206-559-023\***

Parent Item Name: Bearpaw

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2672

Manufactured No

160

Each

0.0000

2

4

**\*D2672\***

Bearpaw 13" X 24", 206

D2732

Manufactured No

160

f

553.8700

2.5

5

**\*D2732\***

Rubber Extrusion

Location

Loc Qty

Loc Code

ST

5

64283

5

ST410

548.87

70987

498.87

73759

50

(D2732-050) cut qty (6) at 5:00" as per dwg \*\*\*per kit\*\*\*

MS21042L4

Purchased

No

160

Each

13,966.00

12

24

**\*MS21042L 4\***

Nut

Location

Loc Qty

Loc Code

ST300

2966

117441

51

117601

537

118451

1378

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

October-20-11 2:54:57 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# REFERENCE ONLY

DART AEROSPACE LTD.

D206-559  
Page 7 of 13

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION I
8	12	8	12			16	D2274	RADIUS BLOCK I
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW I
4	6	4	6				D2438	CLAMP I
8	12	8	12				D2529	WASHER I
	6		6				D2732-050	RUBBER CUSHION I
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT I
8	12	8	12	8	12		AN4-20A	BOLT I
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

• COPYRIGHT © 1990 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: L  
Date: 11.04.08

# Work Order ID 76127

**\*76127\***

Page 1

Monday, November 07, 2011 11:01:03 AM

Item ID: D206-559-023 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw  
 Start Date: 11/7/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 11/8/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: REWORK

Approvals: Process Plan: MP Date: 11-11-07 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-559	rev L								

200 0.00

**\*200\***

Packaging

Packaging

Memo

0.00

PULL FROM STOCK **D206-559-023 X 11 B 76321**

REMOVE OR RECHECK D2732-050 TO ENSURE IT IS CORRECT  
 (WAS TOLD BY STORES THAT IT WAS REMOVED PRIOR TO CLOSING  
 BUT FORGOT TO PUT NEW BATCH NUMBER)

210

**\*210\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

*Cancel already changed*

*scan with original work order*

**Work Order ID 76127****\*76127\***

Page 2

Monday, November 07, 2011 11:01:03 AM

Item ID: D206-559-023

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 11/7/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 11/8/2011 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: REWORK

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*220\***

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

230

QC21- Final Inspection - Work Order Release

0.00

**\*230\***

QC

Memo

0.00

Quality Control

# Picklist Print

Monday, November 07, 2011 11:01:03 AM

Page 1

Work Order ID: 76127

Parent Item: D206-559-023

Start Date: 11/7/2011

Required Date: 11/8/2011

Parent Item Name: Bearpaw

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP Rev: E04.02.17Tolerance added to Step 3KJ/JLM

IPP Rev: F 07-01-02 Was K10006 JLM

IPP Rev:G 08-09-19 Added step 2 JLM Verified By:EC

IPP Rev:H New Manufacturing Method 08-10-29 JLM Verified By:EC

IPP Rev J 10.10.04

per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2732

Manufactured

No

f

491.7100

2.5

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

491.71

70987

488.87

73759

2.84

# Picklist Print

October-20-11 2:54:57 PM

Page 3

Work Order ID: 75321

\*75321\*

Parent Item: D206-559-023

\*D206-559-023\*

Parent Item Name: Bearpaw

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

M/M  
x2  
D2672

D2672

Manufactured No

160

Each

0.0000

2

4

\*D2672\*

Bearpaw 13" X 24", 206

M/M  
x2  
D2732

D2732

Manufactured No

160

f

553.8700

2.5

5

\*D2732\*

Rubber Extrusion

\*\*

\*\*

73110 C 11/10/11

SP

## Location

## Loc Qty

## Loc Code

ST

5

64283

5

ST410

548.87

70987

498.87

73759

50

SP

(D2732-050)-cut-qty (6) at 5-00" as per dwg \*\*\*per kit\*\*\*

MS21042L4

Purchased

No

160

Each

13,966.00

12

24

\*MS21042L4\*

Nut

\*\*

SP 11-11-1

## Location

## Loc Qty

## Loc Code

ST300

2966

117441

51

117601

537

118451

1378

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

241

October-20-11 2:54:57 PM

Shop Packet Print

Page 3